

# Work Order ID 51928

Wednesday, September 09, 2009 11:36:59 A

Page 1

Item ID: D3794-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Gasket

Start Date: 9/11/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: RL

Date: 09-9-09 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3794

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

RB 9-9-10

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RB 9-9-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 80202/10

(412)

**Work Order ID 51928**

Wednesday, September 09, 2009 11:36:59 A

Page 2

Item ID: D3794-1

Accept

Revision ID: A

Item Name: Gasket

Start Date: 9/11/2009 Start Qty: 12.00

Required Date: 9/18/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: *FP14*

0.00



Packaging

Memo

0.00

Packaging

*9/9/09 (12x) SP*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/09/11 HJ**W 09-09-11*

# Picklist Print

Page 1

Wednesday, September 09, 2009 11:37:06 AM

Work Order ID: 51928



Parent Item: D3794-1RevA



Parent Item Name: Gasket

Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	320.4821	7.4552			
NEOPRENE SHEET 0.063												

18 9-9-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

320.4820585

111853

-4.147E-05

112508

320.4821

N/A

112508

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> S1828
<b>Description:</b> Gasket		<b>Part Number:</b> D3794-1
<b>Inspection Dwg:</b> D3794 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

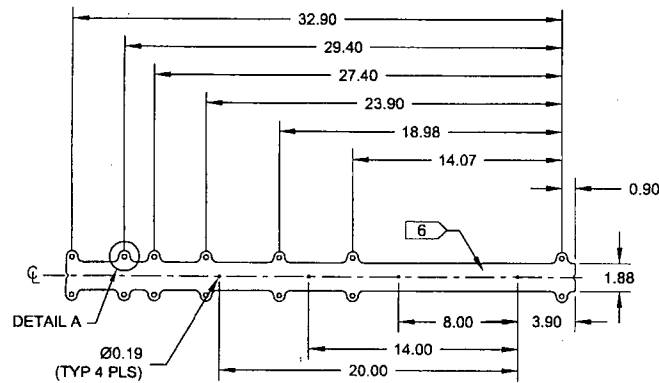
☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.189	*			
0.300 x 0.300	+/-0.010	.301 x .301	*			
1.88	+/-0.030	1.884	*			
0.90	+/-0.030	.902	*			
3.90	+/-0.030	3.903	*			
8.00	+/-0.030	8.00	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
14.07	+/-0.030	14.07	*			
18.98	+/-0.030	18.98	*			
23.90	+/-0.030	23.90	*			
27.40	+/-0.030	27.40	*			
29.40	+/-0.030	29.40	*			
32.90	+/-0.030	32.90	*			

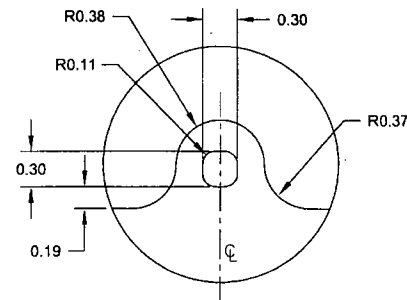
<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-9-10	<b>Date:</b> 05/05/10	<b>Date:</b>	N/A

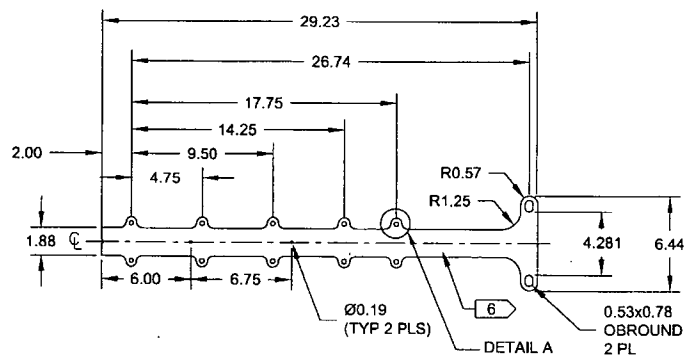
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.05.28	New Issue	KJ/DD	DD



**D3794-1 GASKET**



**DETAIL A**  
SCALE 8X



**D3794-3 GASKET**

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 51928

**RELEASED**  
08-05-14

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	BY	DATE
DRAWN	PH			
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3794		SHEET 1 OF 1
APPROVED		TITLE		SCALE
DE APPR.		GASKET		NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		